

Work Order ID 64057

Tuesday, November 23, 2010 3:55:52 PM



RUSH !!!

Page 1

Item ID: D3608-1

Accept



Setup Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-11-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	<i>PC1 Rev C</i>								
100		0.00							
	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3608 Dwg Rev: <i>PC1</i> Prog Rev: <i>PC1</i> 2-Deburr if necessary								<i>2</i>
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

Siolul24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *175*

0.00



Packaging

Memo

0.00

Packaging

*10/11/24**2*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/11/24**MF*
10-11-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 23, 2010 3:55:52 PM

Page 1

Work Order ID: 64057



Parent Item: D3608-1



Parent Item Name: Lower Doubler

Start Date: 11/24/2010

Required Date: 11/25/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	90.2000	0.7392	1.556211			



304/316 .040 Sheet



11/10-11-23

Location

Loc Qty

Loc Code

MAT

86.2

115762

10.2

115953

76

MAT20

4

113062

1.398

115440

2.602

115953

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 24057
Description: Lower Double		Part Number: D3609-1
Inspection Dwg: D3609-1 Rev: REV C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

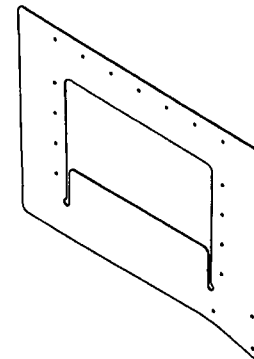
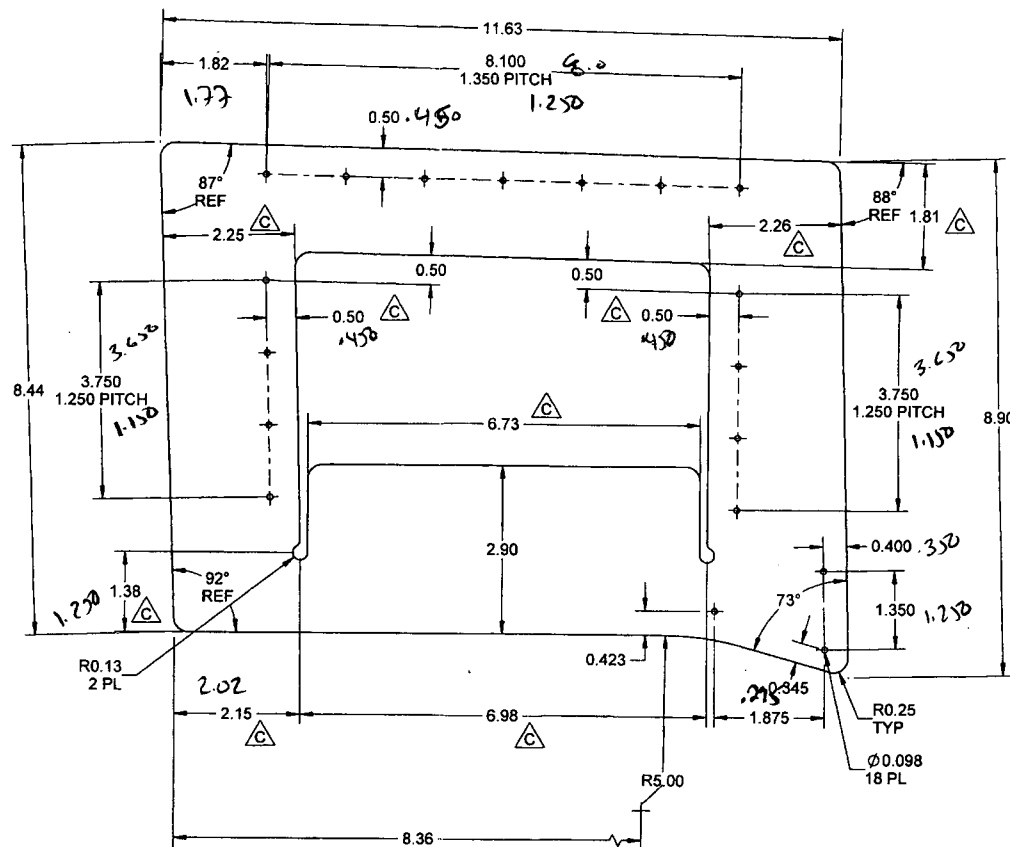
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	±.004-.001	.101	X		V HB02	
1.82	±.030	1.810	✓		V	
1.00	±.030	.505	✓		V	
11.63	±.030	11.621	✓		V PRO HB02	
8.00	±.010	8.097	✗		V PRO HB02	
1.350	±.010	1.351	✓		V	
2.25	±.030	2.235	✗		V	
1.81	±.030	1.810	✗		V	
3.750	±.010	3.749	✓		V	
1.250	±.010	1.249	✗		V	
8.90	±.030	8.890	✗		V PRO HB02	
4.00	±.010	4.00	✓		V	
1.350	±.010	1.350	✓		V	
.345	±.010	.343	✗		V	
1.875	±.010	1.877	✗		V	
6.73	±.030	6.707	✗		V	
2.90	±.030	2.903	✗		V	
6.98	±.030	6.983	✗		V	
1.38	±.030	1.377	✗		V	
8.44	±.030	8.431	✗		V PRO HB02	
.040	±.010	.036	✗		V	

Measured by: JB
Date: 10-11-24

Audited by: S
Date: 10/11/24

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



#64057

RELEASED
2010-11-23

D3608-1 LOWER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM A240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 C
- 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR009-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.11.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3608

TITLE
DOUBLER

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REV. C
SHEET 1 OF 2
SCALE
NTS

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